

Date: Monday, 23/03/2009 9:54:03 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : FWD TUBE ASSEMBLY
<b>Job Number</b> : 46646	
<b>Estimate Number</b> : 10467	
<b>P.O. Number</b> :	<b>Part Number</b> : D3391021
<b>This Issue</b> : 23/03/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3391 REV H
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SKIDTUBES	<b>Drawing Revision</b> : H
<b>Previous Run</b> : 46522	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 06/04/2009
<b>Checked &amp; Approved By</b> : <u>JUD 09.03.23</u>	<b>Qty:</b> 1 <b>Um:</b> Each
<b>Comment</b> :	

Est. A 05.09.13 New issue KJ/JLM  
 Est. B 06.02.10 Dwg rev.D ecn 773 EC  
 Est. C 06.05.02 Added inspections EC  
 est D 07.03.13 rev F dwg EC  
 est E 07.11.07 revG dwg ecn1053P EC verified by: DD  
 Est Rev:f ECN 1056 07-11-12 DD verified by: EC  
 Est Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC  
 Est Rev:H 08-09-10 revH as per dwg DD verified by:EC  
 Est Rev J 09.02.02 added hardware EC verified by: DD

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6013047	Skidtube Material
-----	----------	-------------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SKIDTUBE MAT'L

Pick:

Qty	Part Number	Description	Batch
1	D6013-047	Extrusion	B-26577 MB

①

2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
-----	-------------	-----------------------



**Comment:** LANDING GEAR RESOURCE 1  
 Cut extrusion to 46.52 +0.010 -0.020

MB 09-03-24

①

3.0	BENDING	BENDING MACHINE - SKIDTUBES
-----	---------	-----------------------------



**Comment:** Nc bender  
 Bend as per Dwg D3391 Using Bend Prog 3391021

MB 09-03-24

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 23/03/2009 9:54:03 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 46646

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC5

INSPECT WORK TO CURRENT STEP



13.1°  
6.913" h



Comment: INSPECT WORK TO CURRENT STEP

S 02/03/24 @

5.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA590 Rev. AA & Dwg D3391 Rev. H  
Identify as D3391-1

2-Deburr

J.F. 09/03/31

①

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 09/03/31

①

7.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Drill X1 Aft cap as per Dwg D3391 .1875" dia

SP 09/04/01

①

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SP 09/04/01

9.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L. 09/04/01

10.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)  
(ONLY DRILL HOLES MARKED "A")

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5- open float bag holes 0.328" and counter sink as per dwg D3391

K

9-42

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 23/03/2009 9:54:04 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 46646

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6-Deburr & Scribe Batch number Inside aft end.

M 9-4-2

7-Transfer drill D3391-021 with D3391-023

M 9-4-15

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/15 (to)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

D M 9-4-16

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

AT 09.04.21

14.0

D36704200

SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SPACER

batch:

B46106 D M 9-4-21

15.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-instal spacers as per dwg D3391

A/R Magnabond 6398 batch:

exp. date: 10-2-1

cure time 12hrs. as per QSI015

2- grind crossbolt flush

3-back drill crossbolt if necessary

M 9-04-22 (D)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/23 (to)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

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Drawing Name: FWD TUBE ASSEMBLY

Job Number: 46646

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING PRESSURE-WASH 09-04-28 (X) #1  
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 M 110 939

START TIME: 9:30

OVEN TEMPERATURE: 320°

FINISH TIME: 10:00

BR 09-04-28

(D)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-04-28

(X1)

19.0

D3401041

Tow Cap Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Tow Cap Assembly

1346029

21

20.0

D356413

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Wearshoe

1346183

21

21.0

D356613

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Gasket

1345827

21

22.0

D36721

Phenolic Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Phenolic Washer

1339775

21

23.0

AN3C4A

BOLT



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)  
BOLT

M 111424

21

09-04-28

(X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Drawing Name: FWD TUBE ASSEMBLY

Job Number: 46646

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)  
washer M110985 JLS

25.0

ALS41032130

Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
INSERT M1108606 JLS

26.0

ALS41032225

Insert



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)  
INSERT M110118 JLS

09-04-28



27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

# 469854 get 3 wrapped on mid tube Assy

28.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: SKIDTUBESS RESOURCE 1  
\*\*\*\* install D3591-1 spacer as per DSI9364 \*\*\*\*

JLS

09-04-28



29.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SCRAP DD 09/06/09

Job Completion



UNF 09-06-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

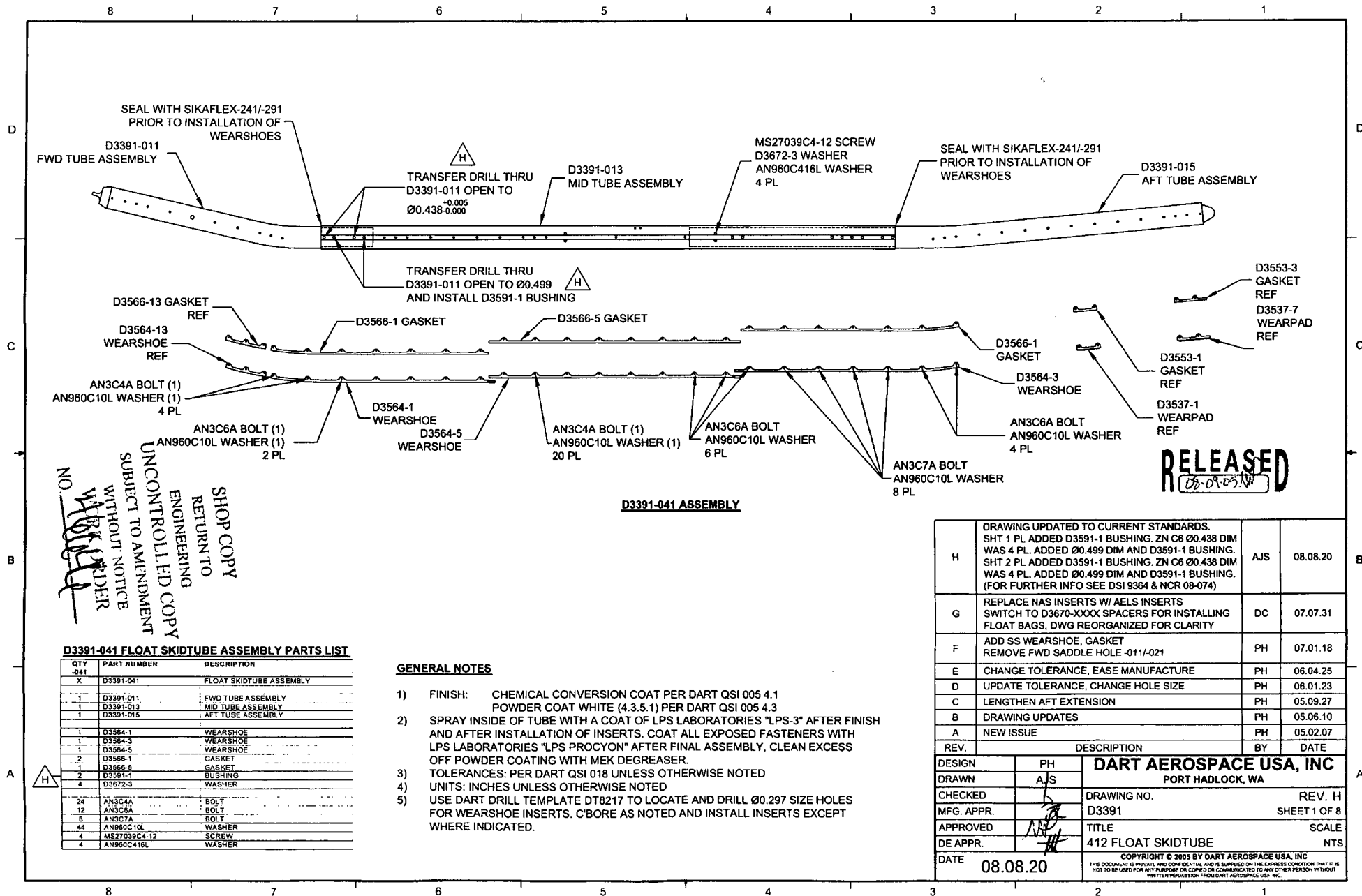
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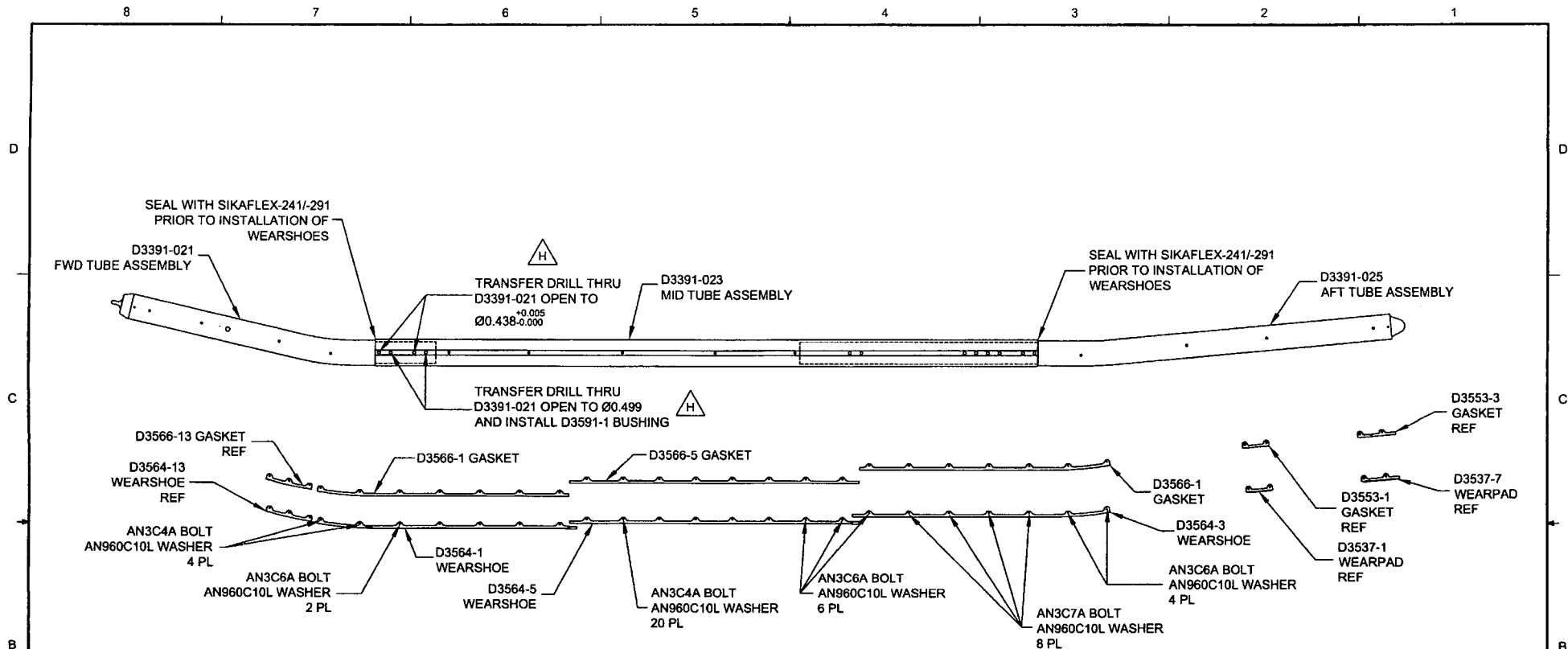
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries







**D3391-043 ASSEMBLY**




**D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
12	AN3C7A	BOLT
4	AN960C10L	WASHER

**GENERAL NOTES**

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C-BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.


**RELEASED**  
08-09-25/14

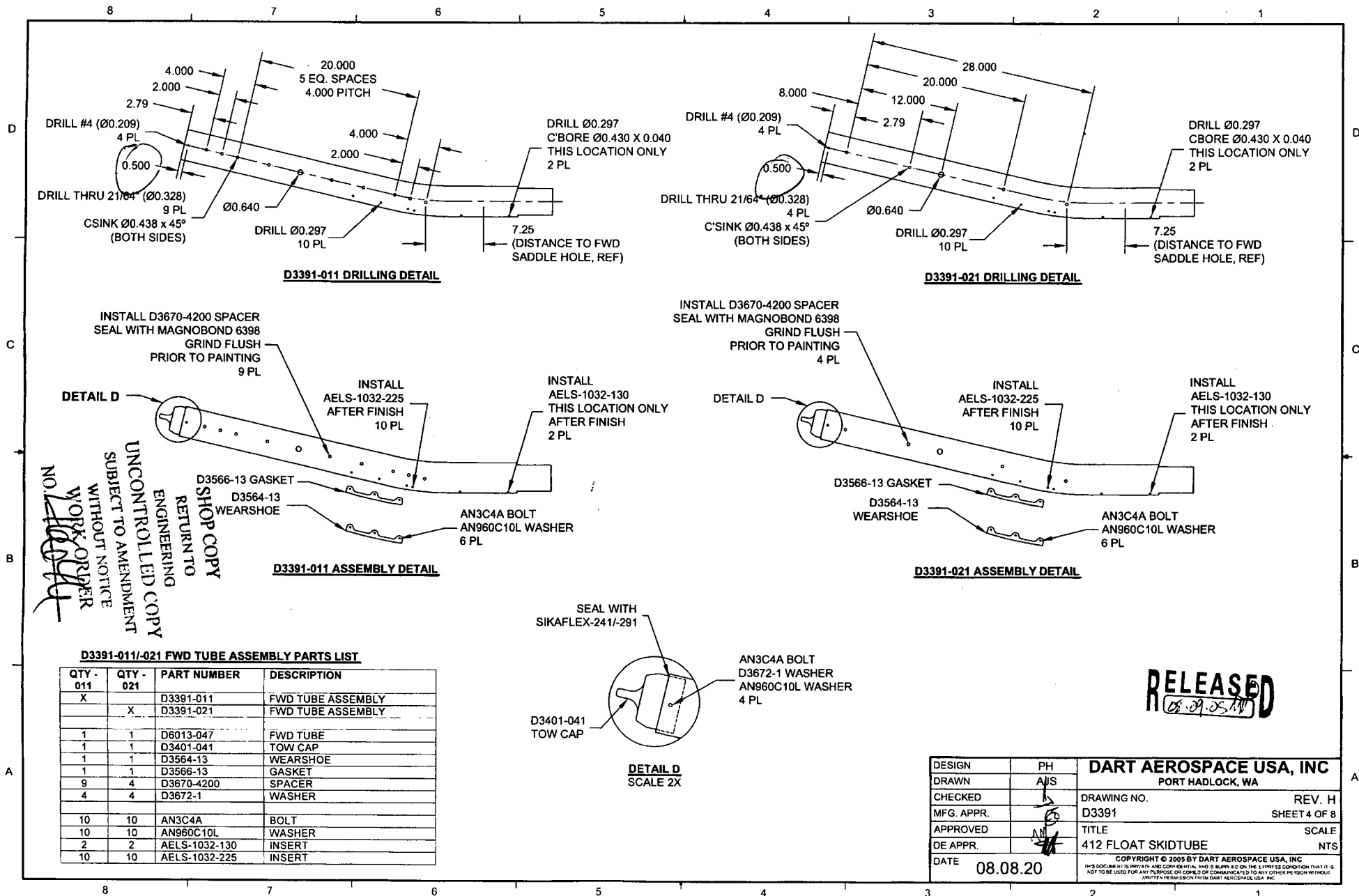
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CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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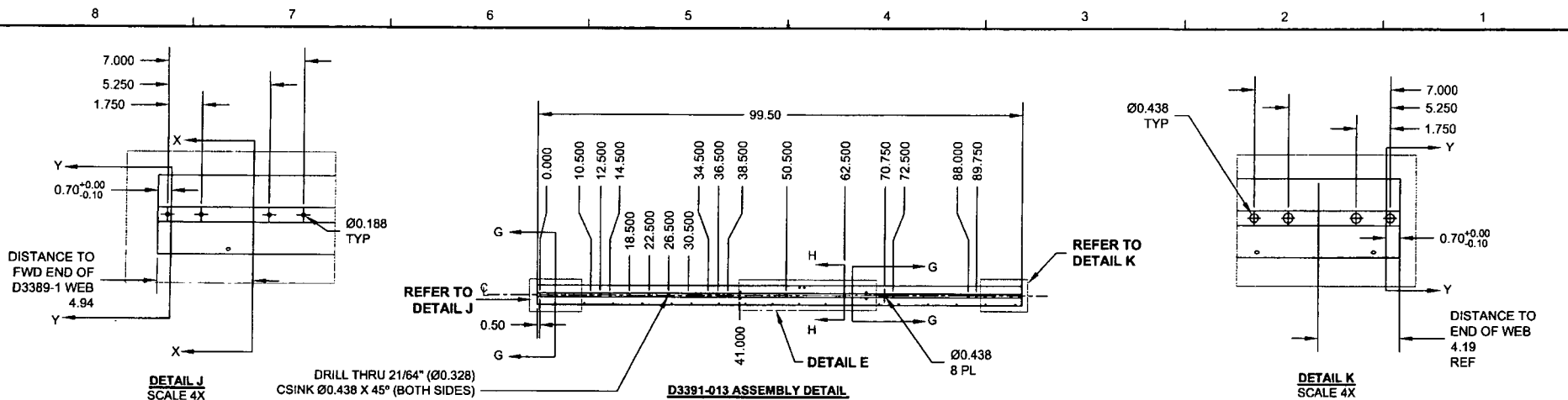
RELEASE  
8-9-05 NW

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MFG. APPR.			
APPROVED			SCALE
DE APPR.			NTS
DATE	08.08.20		

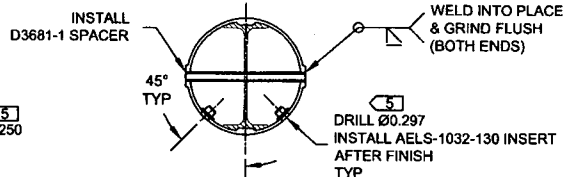


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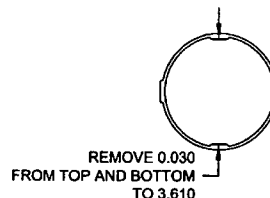
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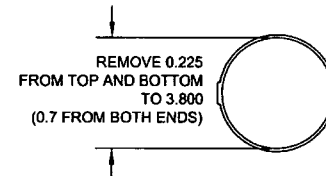
SECTION G-G  
SCALE 5X



SECTION H-H  
SCALE 5X



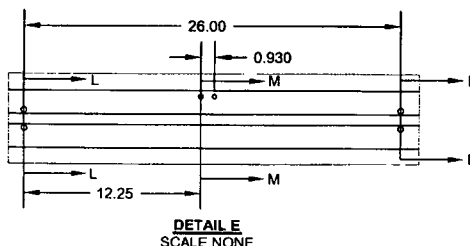
SECTION X-X  
SCALE 5X



SECTION Y-Y  
SCALE 5X

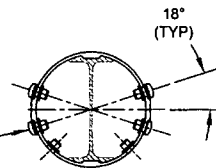
**D3391-013 MID TUBE ASSEMBLY PARTS LIST**

QTY	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

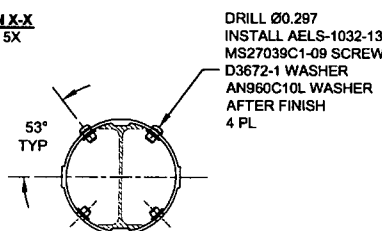


DETAIL E  
SCALE NONE

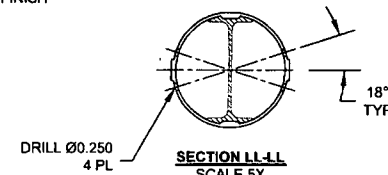
DRILL 0.391  
INSTALL ALS4-428-165 INSERT  
MS27039C4-08 SCREW  
D3672-3 WASHER  
AN960C416L WASHER  
AFTER FINISH  
4 PL



SECTION L-L  
SCALE 5X



SECTION M-M  
SCALE 5X



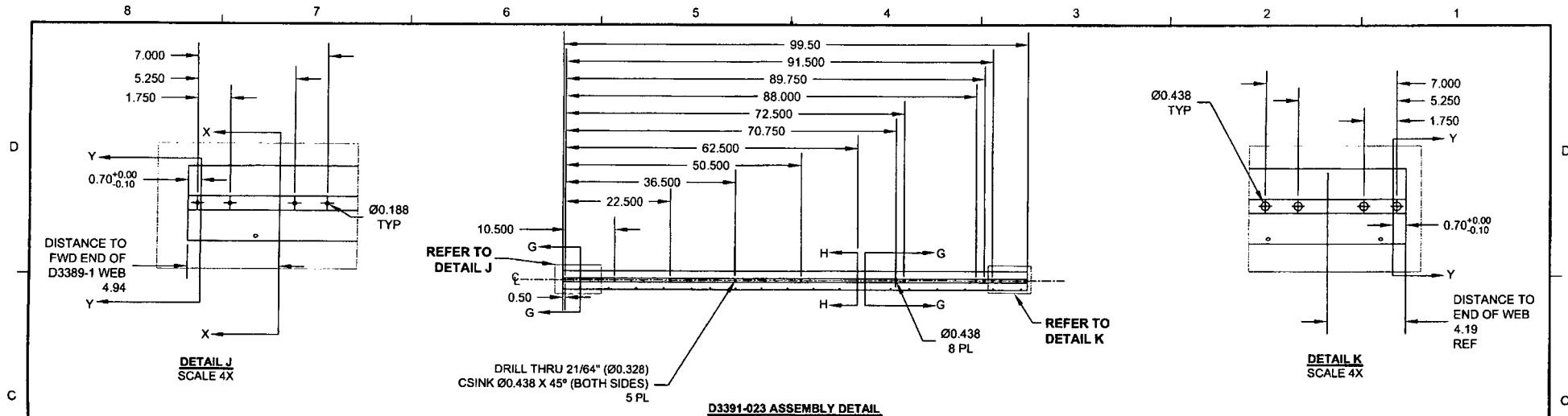
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NO. 160490  
WORK ORDER  
SUBMIT AMENDMENT  
WITHOUT NOTICE  
1. MATERIAL: MAKE FROM D2500-1-100 EXTRUSION  
2. INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015  
3. WELDING: PER DART QSI 004  
COPY  
RETURN TO  
ORIGINAL COPY  
FOR AMENDMENT

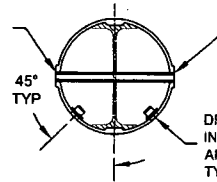




NO WORK ORDER  
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WITHOUT NOTICE  
ENGINEERING  
RETURN TO  
SHIP COPY

SECTION G-G  
SCALE 5X

INSTALL  
D3681-1 SPACER

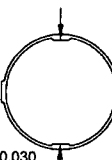


SECTION H-H  
SCALE 5X

WELD INTO PLACE  
& GRIND FLUSH  
(BOTH ENDS)

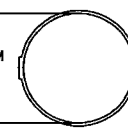
DRILL Ø0.297  
INSTALL AELS-1032-130 INSERT  
AFTER FINISH  
TYP

REMOVE 0.030  
FROM TOP AND BOTTOM  
TO 3.610



SECTION X-X  
SCALE 5X

REMOVE 0.225  
FROM TOP AND BOTTOM  
TO 3.800  
(0.7 FROM BOTH ENDS)



SECTION Y-Y  
SCALE 5X

# D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

## D3391-023 MID TUBE ASSEMBLY

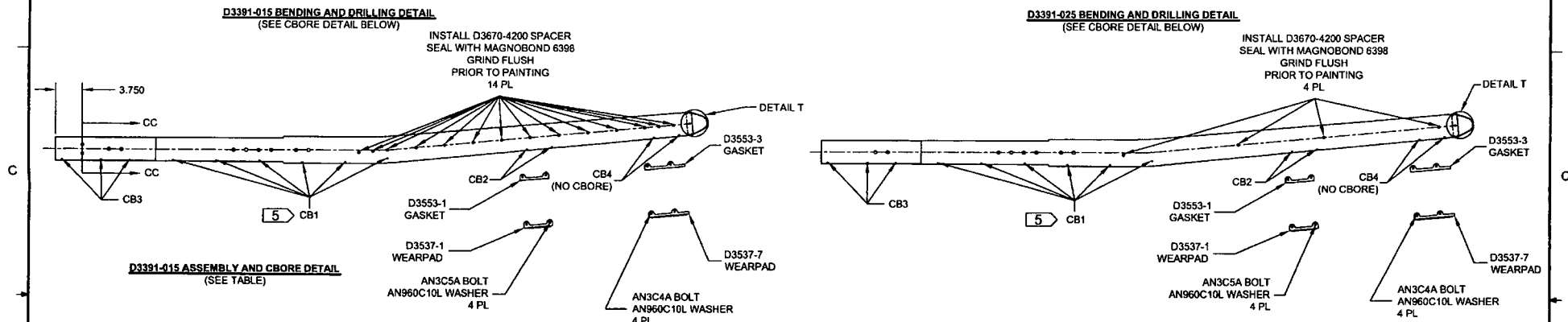
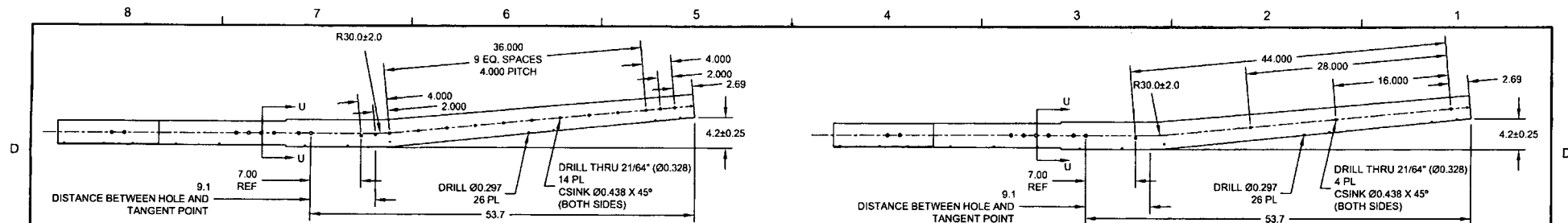
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

RELEASED  
08-09-05-17

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>
DRAWN	AS	PORT HADLOCK, WA
CHECKED		DRAWING NO. REV. H
MFG. APPR.		D3391 SHEET 6 OF 8
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DE APPR.		412 FLOAT SKIDTUBE NTS
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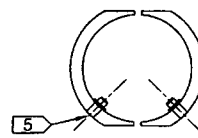
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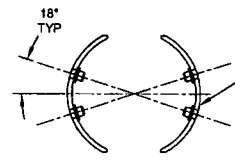


#### D3391-015-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
14	14	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
4	4	ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER

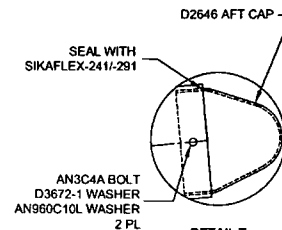


SECTION U-U  
SCALE 3X



SECTION CC-CC  
SCALE 3X

DRILL Ø0.391  
CBORE Ø0.516 X 0.040 DEEP  
INSTALL ALS4-428-165 INSERT  
4 PL



DETAIL T  
SCALE 4X

CBORE HOLES MARKED CB1-CB4 AS FOLLOWS AND  
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2003 BY DART AEROSPACE USA, INC	

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